

44

20.88

DART AEROSPACE LTD		Work Order:	19534
Description: Long Step Assembly – High Skid, RH		Part Number:	704A 41 640 007
D350-591-212			
Dwg: D3070 Rev. A1		Qty:	105
RF 02-11-13		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	10	03.08.27	10 5
2	DC	Photocopy bluefile and type labels per PPP 704A 41 640 007 CHG001 CHG 001 WK 42	10	03.10.07	10 5
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3070 using cutting table setup DT8185-2A Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion B18809 Ensure wall thickness is 0.070 to 0.090	ml	04-02-02	5
4	GA	Drill extrusion per Dwg D3070 using Jig DT8680 for rivets.	ml	04-02-02	5
5	GA	Deburr	ml	04-02-02	5
6	QC5	Inspect work to Step 5	B	04-02-02	5
7	WA	Bevel end for welding FWD ONLY	M	04/02/06	5
8	WA	Weld Support using Jig DT8681, weld Fwd End Plate per QSI 004 & Dwg D3070 Pick: Qty Part Number Description Batch 1 D3063-1 Support B19555 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	M	04/02/06	5
9	GA	Grind End Plate flush	M	04/02/06	5
10	QC9	Inspect weld and work to Step 9	B	04-02-11	5
11	FP	Chemical conversion coat as per QSI 005 4.1	2	04-02-13	5
12	GA	Assemble Leg Assembly as per Dwg D3070. D3066-1 are done with Step Leg Assy, don't add to the BOM. RF 03-01-10 Pick: Qty Part Number Description Batch 1 D3065-041 Step Leg Assy B19557 2 D3066-1 Spacer B19557 16 MS20600AD4W4 Rivet M13767	B	02/01/15	5
13	QC5	Inspect work to step 12	M	04/02/19	5
14	WA	Bevel Aft end for welding	M	04/02/19	5
15	WA	Inspect for foreign object per QSI 024	M	04/02/19	5
16	WA	Weld Aft End Plate per QSI 004 & Dwg D3070 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	M	04/02/19	5

BR 04-02-25 DR

CANCEL RF 03-01-16
UNDER REVIEW
03-06-06 RF
See David

RELEASED
02/11/01 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	19534
Description: Long Step Assembly – High Skid, RH D350-591-212	Part Number:	704A 41 640 007
Dwg: D3070 Rev. A1	Qty:	105
Page 2 of 2		

17	GA	Grind End Plate flush	50	04/02/19	5																																																				
18	QC9 & 5	Inspect work to Step 17 – Check dimension 110.56" from Dwg D3070 110.71" RF 02.11.13	18	04.02.20	5																																																				
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	2	04.02.23	5																																																				
20	FP	Wing Walk per Dwg D3070 and QSI 005 4.4	M	04.02.23	5																																																				
21	QC3	Inspect Powder Coat and Wing Walk	(P)	04.02.24	5																																																				
22	KP	Pick: Packing Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4✓</td><td>D2182B035</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>8✓</td><td>D2274</td><td>Radius Block</td><td>B20207</td></tr><tr><td>2✓</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B18972</td></tr><tr><td>2✓</td><td>D3064-1</td><td>Clamp</td><td>B20123</td></tr><tr><td>1✓</td><td>D3070-041</td><td>Support Assy</td><td>B20056</td></tr><tr><td>4✓</td><td>D3080-1</td><td>Clamp</td><td>B19559</td></tr><tr><td>2✓</td><td>AN3-35A</td><td>Bolt</td><td>M13943</td></tr><tr><td>10✓</td><td>AN4-11A</td><td>Bolt</td><td>M13735</td></tr><tr><td>4✓</td><td>AN960JD10</td><td>Washer</td><td>M13719</td></tr><tr><td>20✓</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>2✓</td><td>MS21042L3✓</td><td>Nut (or -3)</td><td>M14019</td></tr><tr><td>10✓</td><td>MS21042L4✓</td><td>Nut (or -4)</td><td>M13276</td></tr></table>	Qty	Part Number	Description	Batch	4✓	D2182B035	Rubber Cushion	B19540	8✓	D2274	Radius Block	B20207	2✓	D2856-400-720	Abrasion Strip	B18972	2✓	D3064-1	Clamp	B20123	1✓	D3070-041	Support Assy	B20056	4✓	D3080-1	Clamp	B19559	2✓	AN3-35A	Bolt	M13943	10✓	AN4-11A	Bolt	M13735	4✓	AN960JD10	Washer	M13719	20✓	AN960JD416	Washer	M13719	2✓	MS21042L3✓	Nut (or -3)	M14019	10✓	MS21042L4✓	Nut (or -4)	M13276	CR.	04.02.24	5
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23	QC4	Inspect 100% Kit for Completeness on the W/O	B	04.02.24	5																																																				
24	PK	Package for shipping as per PPP 704A 41 640 007	B	04.02.24	5																																																				
25	AC	Cost / part 243.62	545	04.02.25	5																																																				
26	DC	Close W/O 243.62 Inspect Level 21	KA	04.02.26	5																																																				

Rev	Date	Change	Revised By	Approved
A	02.11.01	New issue	KJ RF	
A1	03.01.14	110.71" WAS 110.56" ; Dwg. Rev. A1	RF	
A2	03.07.16	D3194-041 WAS D3070-041 ; CHG002	RF	

UNDER REVIEW

03.06.06 RF

See David

CANCEL RF 03.01.16

RELEASED
02/11/02

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
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PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 27, 2003
02:05 pm

Work Order No	: 0019534	Department Code:	
Project Name	: *704A 41 640 007	Burden Flags	: NNNNNNNN
Project For	: wk344	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *704A 41 640 007	Invoice Number	:
Description	: Heli-Access-Step, Long RH	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 10 5	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 08-27-03	Actual Margin	: 0.000%
Est Finish Date	: 11-06-03		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00		
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00